

Monday, 4/10/2006 11:14:58 AM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG
Part Number :	26625	Part Number :	D28073
Alternate Number :	10337	Drawing Number :	D2807 REV C
Issue Number :	N/A	Project Number :	N/A
Issue Date :	4/10/2006	Drawing Revision :	C
Issue Rev. :	NC	Material :	N/A
Issue :	N/A	Due Date :	4/17/2006
Issue Rev. :	23479	Qty :	50 Um: Each
Drawn By :	SEE COMMENT BELOW		
Checked & Approved By :	06.04.10		
Comment :	Est A 05.06.02 New Issue KJ/JLM		

split 2

Material : 303 Round Bar .75"

Seq. # : 1 Machine Or Operation : 303 Round Bar .75"

Comment: Qty.: 0.1094 f(s)/Unit Total : 5.4705 f(s)
Material: 303 Round Bar Ø0.750"
(M303R0.750) Batch: M100415

2-Debur HARDINGE HARDINGE CNC LATHE SMALL

Comment: HARDINGE
Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Debur QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

Comment: Haas #1
Machine as per Folio FA528 and Dwg D2807 Dwg Rev: C
Folio Rev: C

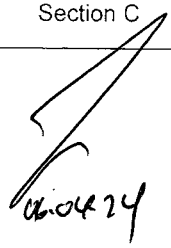
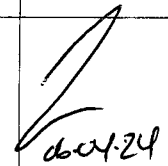
2-Debur QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	QC	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/04/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/24	# 2.0	34 Parts affected when the Drill went too deep. Drill was about 0.050" too deep.	CP 06.04.24 Pir Q81042	SCRAP	AD 06/04/24	 06.04.24	CP 06.04.24 Pir Q81042	 06.04.24

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 26625

Part Number: D28073

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/04/21 425

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FF 06.04.21

2

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/24

23

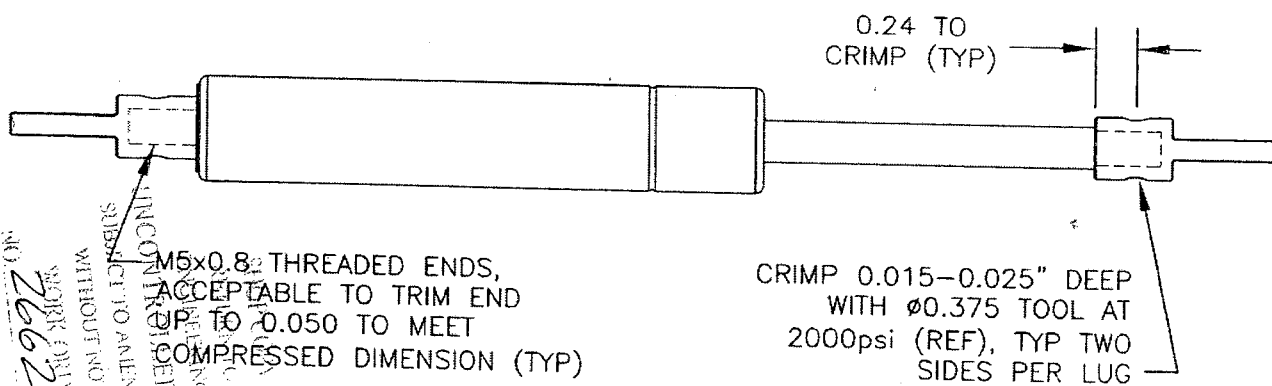
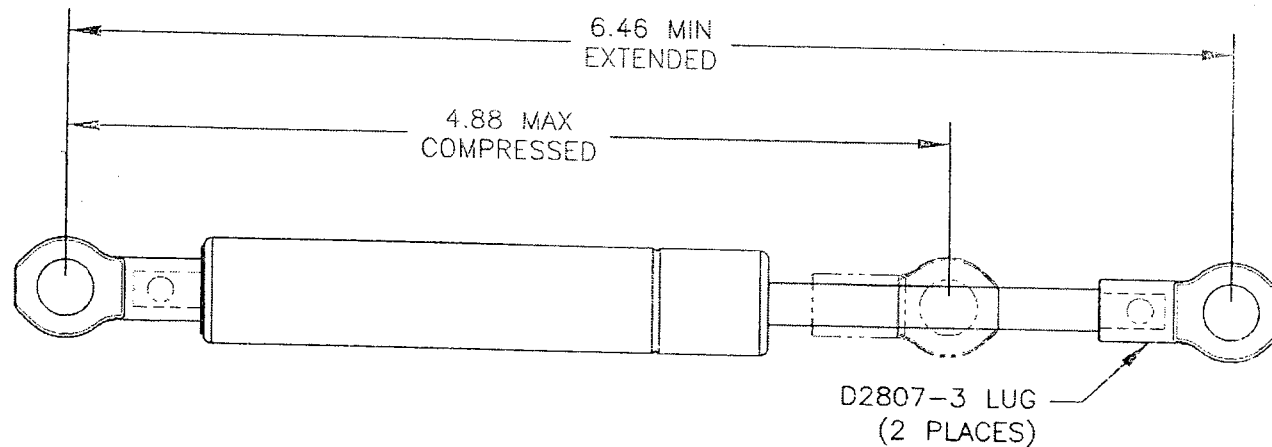
Job Completion



u 06-04-21

DART

RELEASED
#5-6-11



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
CP TO 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 26625

D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. C
DATE	05.05.25	DRAWING NO.	D2807	SHEET 1 OF 2
		TITLE	GAS SPRING	SCALE
				1:1
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		

